



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D4961-043
Job Sheet 169572



Part No: D4961-043

Job Qty: 5 ea

Part Name: Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 12/15/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP REV:A 15.02.18 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		12/14/17	0.00	0.00	Start Up Small Fab-4		FF
110	Small Fab	5 pcs		12/15/17	0.00	3.12	Small Fab-8		FF DAS 38
120	QC	5 pcs		12/15/17	0.00	0.00	QC5		38
130	Packaging	5 pcs		12/15/17	0.00	0.00	Packaging3-2	5/129	3-88
140	QC21-SA	5 Ea		12/15/17	0.00	0.00	QC21		DAS 3-88

Part Op 110 - 1- Cut D4961-3 tube to size as per dwg 2- On one side of tube flare end as per dwg then slide sleeves and nuts.

Descriptions: flare other side of tube as per dwg.

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	AN818-L12J	10	85	0	0
	M304TR0.750W.049	1	155	0	0
	MS20819-12J	10	42	0	0

Part Specifications

Specifications could not be found.

AN 818-L12J

M 304TR0.75W.49

MS 20819-12J

AS000542 (4)
5014158 (2)

5017137

FM 138040 (8)
5014159 (2)

Plex 12/13/17 3:33 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description: _____	DISPOSITION Rework ☐ Scrap ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube</td> <td style="width:15%;">Cross tube</td> <td style="width:15%;">Water Jet</td> <td style="width:15%;">Engineering</td> </tr> <tr> <td>Machining</td> <td>Small Fab</td> <td>Prod. Eng. Coord.</td> <td>Quality</td> </tr> <tr> <td>Thermoforming</td> <td>Finishing</td> <td>Rec/Store/Packaging</td> <td>Other</td> </tr> <tr> <td></td> <td>Composite</td> <td>Supplier</td> <td></td> </tr> </table>				Skid-tube	Cross tube	Water Jet	Engineering	Machining	Small Fab	Prod. Eng. Coord.	Quality	Thermoforming	Finishing	Rec/Store/Packaging	Other		Composite	Supplier	
Skid-tube	Cross tube	Water Jet	Engineering																		
Machining	Small Fab	Prod. Eng. Coord.	Quality																		
Thermoforming	Finishing	Rec/Store/Packaging	Other																		
	Composite	Supplier																			
				MRB (QSI042) Approval																	
				Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	

Job No: 169572
 Mtg Date: 12/14/17

Start up Operation

D4961-043

PART NO:
 Revision:
 Operation:
 Change No:

Tube Assembly

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S021770

Root Cause			
Environment	No Re-verification	Pressing	Power Loss/Surge
Design	Operator	Bending	olio/Program
Doc/Data	Offset/Setup	Centre Not Concentric	Grain
Equip/Tooling	Supplier	Cracks	Weld
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Wrong Stock Pulled
Material	Use for Testing	Cuffs	Out of Sequence
Internal Transport	Poor Information	Crushing	Off-set
Tribal Knowledge	Rushing	Heat Treat	Mislabeled
LOA	Product Improvement	Wave/Twist in Tube	Fit/Function
Substation	Process Improvement	Marks/Chatter	Misaligned/off center
Past Expiry Date	Manufacturing Process		
Misidentified	Past Due		
OTHER : _____			